

First

Work Order ID 87532

July-17-12 2:33:41 PM

87532

Page 1

Item ID: D2438

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Clamp

Start Date: 7/17/12

Start Qty: 60.00

60

Cust Item ID:

Required Date: 7/20/12

Req'd Qty: 60.00

60

Customer:

Reference:

Approvals:

Process Plan: *[Signature]*

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2438	Rev C								

100

0.00

100

Waterjet

PURCHASING

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D2438

prog rev: *C*

dwg rev: *C*

304.063

60 0 *Jun 12-7-12*

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

Ensure Material Release Note is attached

60 0 *Jun 12-7-12*

120

0.00

120

QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

(6.786" center to center)

Smb
12-7-18

DAS
16
9-88

17/07/18

counts
(60)

87532

July-17-12 2:33:42 PM

N900040100

Setup Start ***NS1***

Stop *NS2*

60

Cust Item ID:

Start Qty: 60.00

60

Customer:

Required Date: 7/20/12

Req'd Qty: 60.00

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

130

0.00

130

Small Fab

0.00

Small Fab

Memo

Small Fab

1- Use DT9713 clamp holder to hold clamp in place when forming
2- Bend as per dwg usind DT9709

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Quality Control

Memo

0.00

150

Identify as per dwg & Stock Location: 50

0.00

150

Packaging

Packaging

Memo

0.00

Work Order ID 87532

July-17-12 2:33:42 PM

87532

Page 3

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Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Clamp

Start Date: 7/17/12

Start Qty: 60.00

60

Cust Item ID:

Required Date: 7/20/12

Req'd Qty: 60.00

60

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/17/20
MF
12-07-17

Picklist Print

July-17-12 2:33:41 PM

Page 1

Work Order ID: 87532

Parent Item: D2438

Parent Item Name: Clamp

Start Date: 7/17/12

Required Date: 7/20/12

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP: E05.06.28Bending removedKJ/JLM

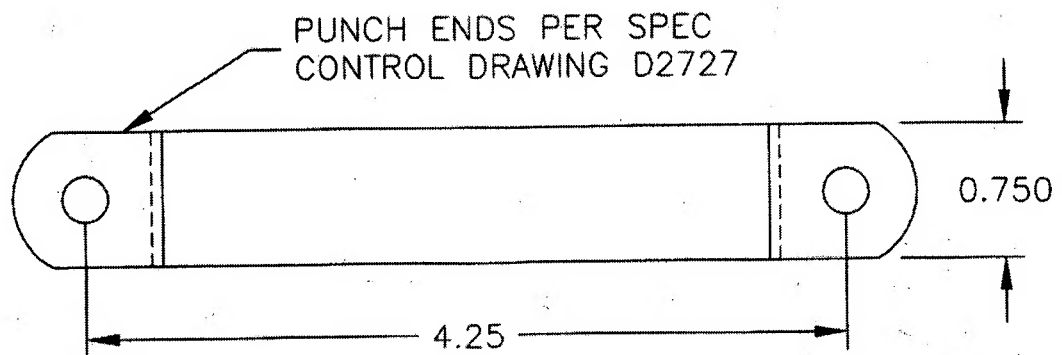
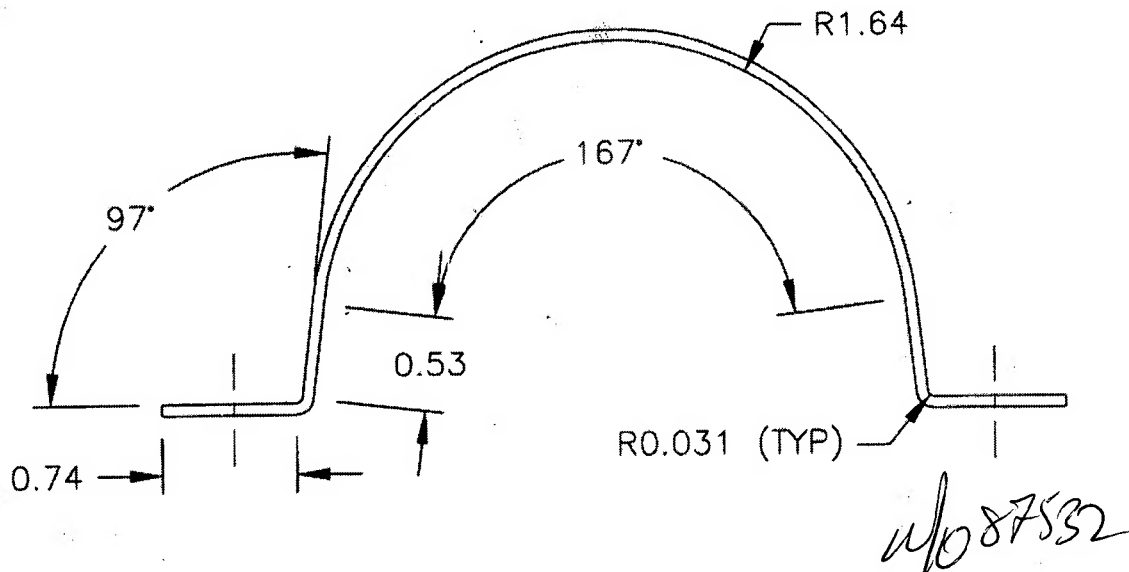
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	289.1400	0.04	2526318 26			5m 12-7-12
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT020		289.14							
				122245		129.14			122245				
				122321		160							

DART



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2438	REV. C SHEET 1 OF 1
DATE 98.05.12		TITLE CLAMP	SCALE 1:1
A	96.01.24	NEW ISSUE	
B	96.05.13	CHANGE LENGTH	
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY	

RELEASED
98.06.17 KE



FLAT LENGTH: 7.586 END-END
6.786 HOLE-HOLE

MATERIAL: AISI 304/316 SS 0.063 THICK

MINIMUM REQUIREMENT IS ANNEALED CONDITION

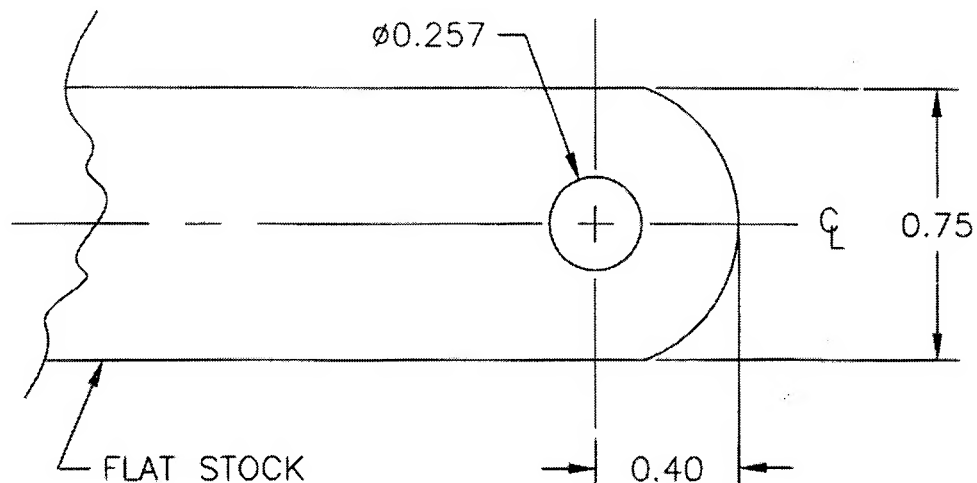
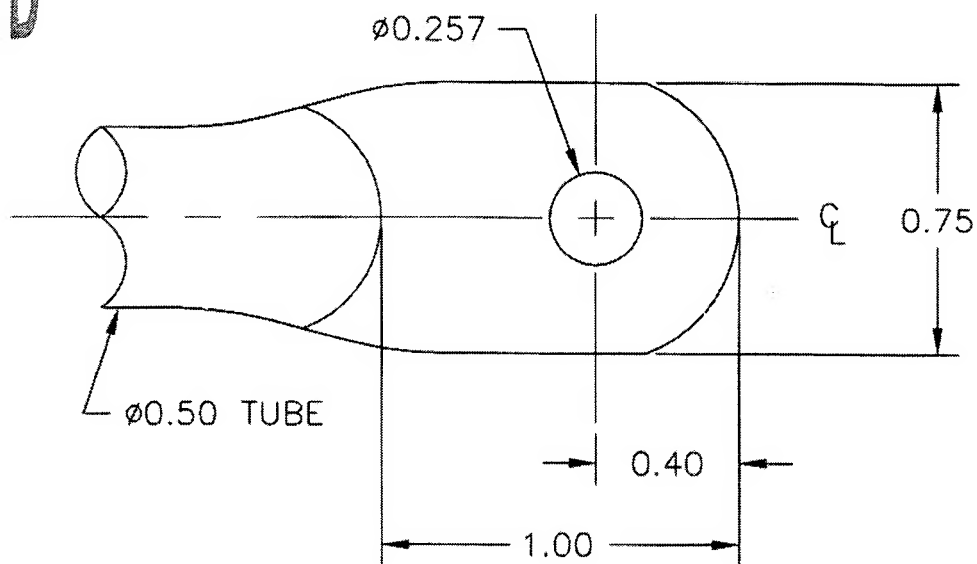
00.06.06
CP 00.06.07



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED MAY	APPROVED JA	DRAWING NO. D2727	REV. A SHEET 1 OF 1
DATE 97.11.24		TITLE PUNCH DT8012 SPEC CONTROL	SCALE 2:1
A	97.11.24	NEW ISSUE	
A1	#10 01.12.20	ADD TOLERANCE NOTE	

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8012

RELEASED
94/03/06 KE



NOTE: TOLERANCES ARE PER DART QSI DIB UNLESS OTHERWISE NOTED.

